

ABSTRACT

The invention relates to a method for injecting an injection molded part made of plastic, using an injection unit having a gate (1) in a nozzle housing (2), the gate (1) being connected to a flow channel (5). According to the invention, the gate (1) is opened and closed by an inner needle (4), and plastic flowing from the flow channel (5) to the gate (1) is predosed and injected by an outer needle (3), and/or a retention pressure is applied to the plastic.